

Work Order ID 122448

July-18-14 10:27:19 AM

D 4000-1
B 122448

122448

RUSA

Page 1

Item ID: D4000-1

Revision ID:

Item Name: Fuel Supply Fitting

Start Date: 7/18/14

Start Qty: 12.00

12

Required Date: 7/18/14

Req'd Qty: 12.00

12

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MLJ

Date: 14-07-18

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4000

BC DF 8 14/07/18

100

Cut blanks as per folio

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK

1.800 Long

105

0.00

105

Doosan

Memo

0.00

Doosan Lathe

Turn as per DWG and Folio Fa908

Folio Rev: N/A

Dwg Rev: C

TAP USING DT9585 TAPPING BLOCK

Deburr

DAS
13
9-89

DAS
13
9-89

12 0 14-7-20

12 0 14-7-20

Work Order ID 122448

July-18-14 10:27:19 AM

122448

Page 2

Item ID: D4000-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fuel Supply Fitting

Start Date: 7/18/14

Start Qty: 12.00

12

Cust Item ID:

Required Date: 7/18/14

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

DAS
13
9-89

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12 ϕ 14-7-20

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

125

Chemical Conversion

PLM / 14/07/22
DAS 27 9-89
MHI 22

127

QC7

12 ϕ

130

Identify as per dwg & Stock Location: G-A

0.00

130

Packaging

Memo

0.00

Packaging

12 14/07/22
DAS 36 9-89

Work Order ID 122448

July-18-14 10:27:19 AM

122448

Page 3

Item ID: D4000-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fuel Supply Fitting

Start Date: 7/18/14

Start Qty: 12.00

12

Cust Item ID:

Required Date: 7/18/14

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

14/7/22

7-22

Picklist Print

July-18-14 10:27:22 AM

Page 1

Work Order ID: 122448

122448

Parent Item: D4000-1

D4000-1

Parent Item Name: Fuel Supply Fitting

Start Date: 7/18/14

Required Date: 7/18/14

Start Qty: 12.00

Required Qty: 12.00

Comments: Ipp Rev:A New Issue 10-01-28 JLM Verified By:EC
10.05.13 ecn10-562 EC verified by:DD

IPP rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6R3.250

Purchased

No

f

3.3500

1

M6061T6R3 250

14-7-20

6061-T6 RD BAR 3.250"

Location

Loc Qty

Loc Code

MAT

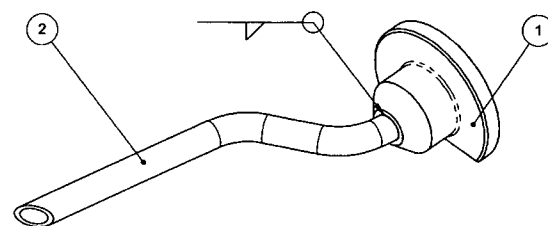
3.35

m129530

3.35

2 LF

ITEM	QTY -041	P/N	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
	X	D4000-041	DRAIN FITTING ASSEMBLY, AFT	JCA-M47-1-06
1	1	D4000-3	FUEL SUMP DRAIN FITTING	
2	1	D4003-1	INTERNAL DRAIN LINE, AFT	



D4000-041 DRAIN FITTING ASSEMBLY, AFT

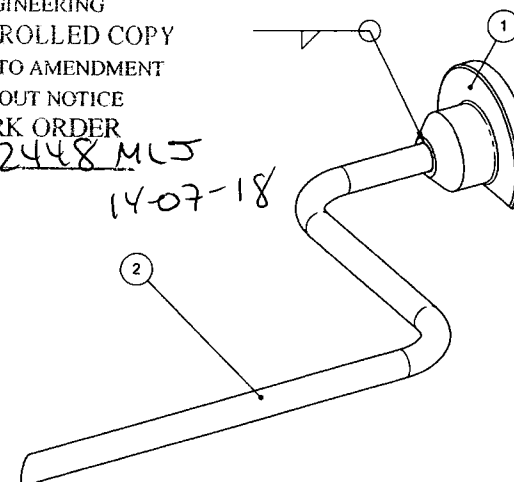
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.6
- 7) WEIGHT: D4000-041 - 0.04 lbs
D4000-043 - 0.05 lbs
- 8) WELD PER QSI 004

ITEM	QTY -043	P/N	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
	X	D4000-043	DRAIN FITTING ASSEMBLY, FWD	JCA-M47-1-15
1	1	D4000-3	FUEL SUMP DRAIN FITTING	
2	1	D4003-3	INTERNAL DRAIN LINE, FWD	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 122448 MLJ

14-07-18



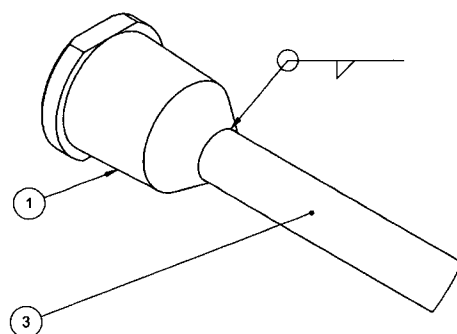
D4000-043 DRAIN FITTING ASSEMBLY, FWD

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2014-07-17
JMP

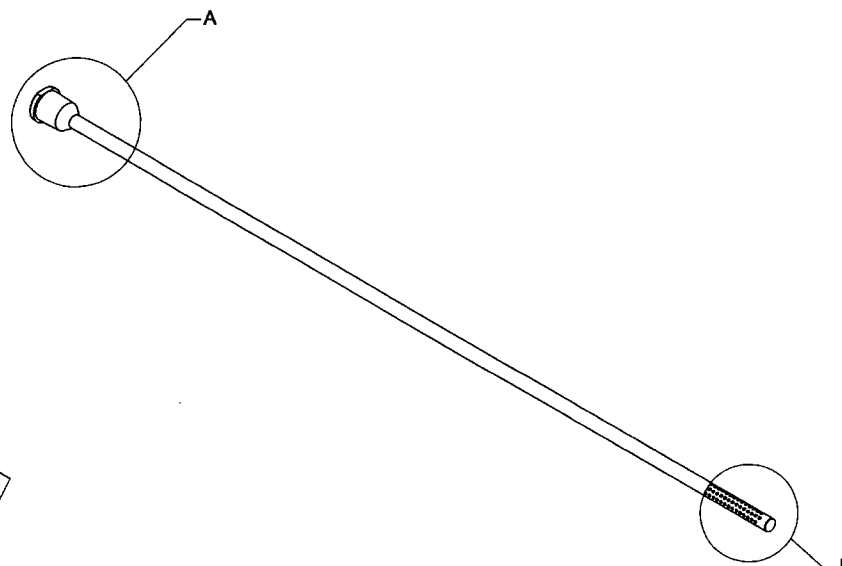
C	REMOVED COUNTERSINK FROM D4000-1 (ZNC5-3) ADD CHEMICAL CONVERSION COAT TO NOTE 2, SHEET 3	ML	14.06.27
B	RE-DESIGN D4000-1 TO BE RIVETED (ZNC5-3) UPDATED BOM FORMAT ON SHEET 1 AND 2, UPDATE NOTE 6	ML	14.05.30
A	NEW ISSUE	HS	10.02.10
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	DD	D4000	SHEET 1 OF 8
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	FITTING	NTS
DATE	14.06.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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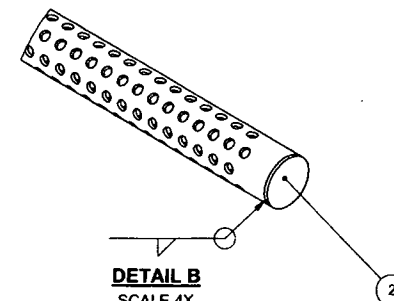
ITEM	QTY -041	P/N	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
	X	D4000-045	FUEL PICK UP FITTING ASSEMBLY	JCA-M47-1-10
1	1	D4000-7	FUEL PICK UP FITTING	
2	1	D4000-11	CAP	
3	1	D4003-5	FUEL PICK UP LINE	



DETAIL A
SCALE 4X



D4000-045 FUEL PICKUP FITTING ASSEMBLY



DETAIL B
SCALE 4X

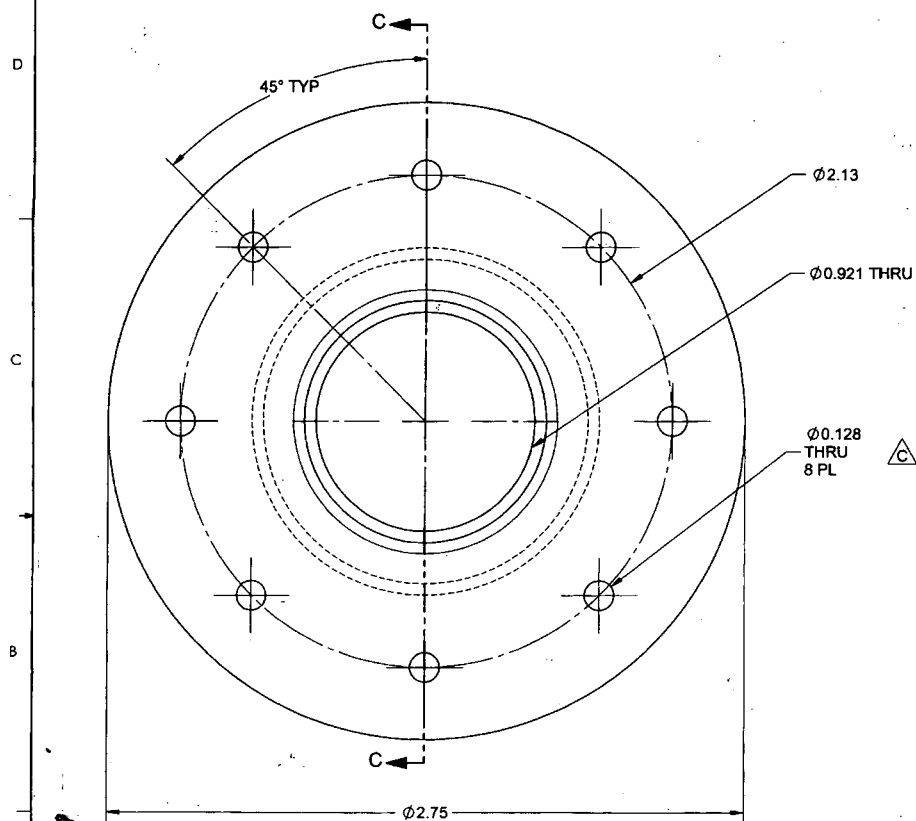
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.6
 - 7) WEIGHT: 0.27 lbs
 - 8) WELD PER QSI 004

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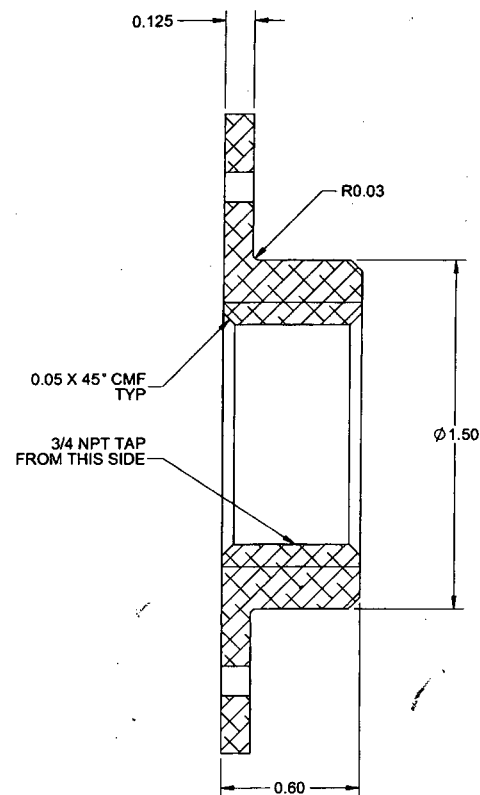
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	CP	DRAWING NO. D4000	REV. C
MFG. APPR.	DD		SHEET 2 OF 8
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	FITTING	NTS
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2014-07-17

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-1	JCA-M47-1-04



D4000-1 FUEL SUPPLY FITTING



SECTION C-C

RELEASED
2014-07-17

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.7
- 7) WEIGHT: 0.11 lbs

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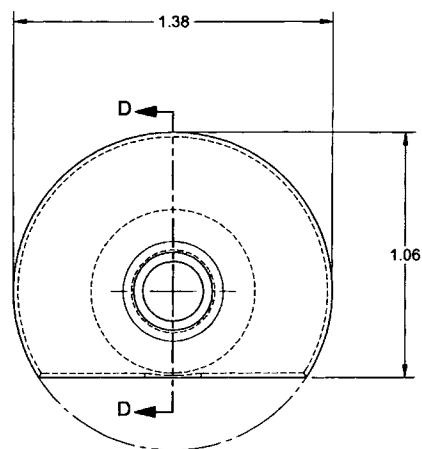
DESIGN	HS
DRAWN	ML
CHECKED	CP
MFG. APPR.	DD
APPROVED	MP
DE APPR.	DS
DATE	14.06.27

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

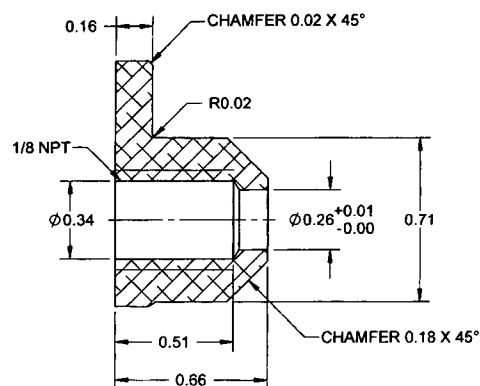
DRAWING NO. D4000	REV. C SHEET 3 OF 8
TITLE FITTING	SCALE NTS

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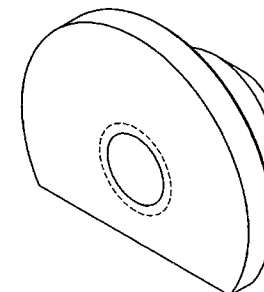
DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-3	JCA-M47-1-05



D4000-3 FUEL SUMP DRAIN FITTING



SECTION D-D



NOTES:

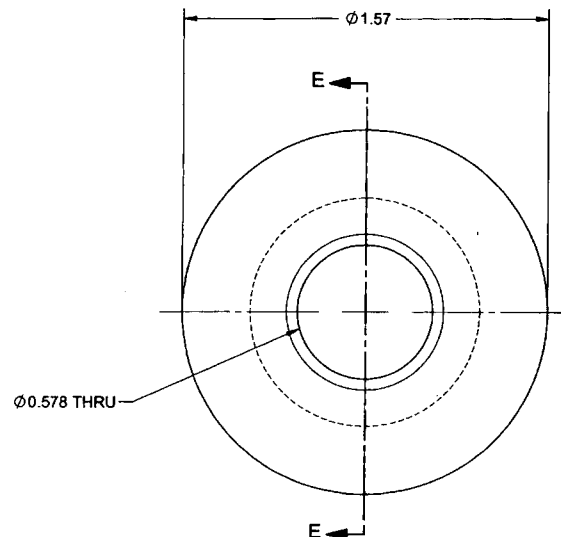
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

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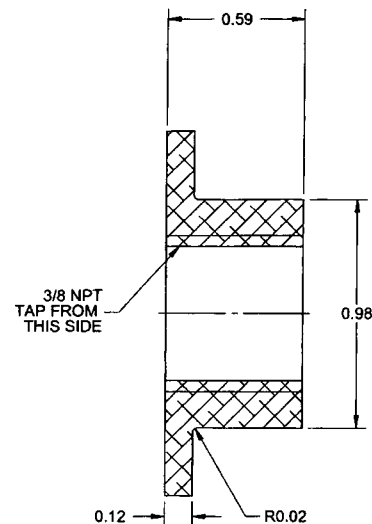
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	DD	D4000	SHEET 4 OF 8
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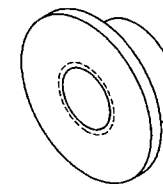
DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-5	JCA-M47-1-09



D4000-5 FUEL TANK VENT FITTING



SECTION E-E



NOTES:

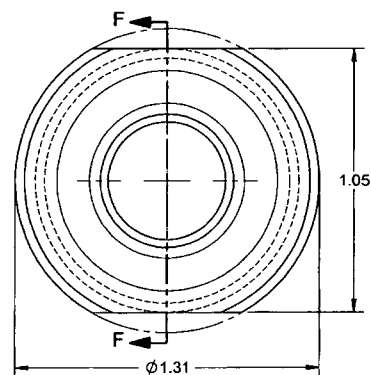
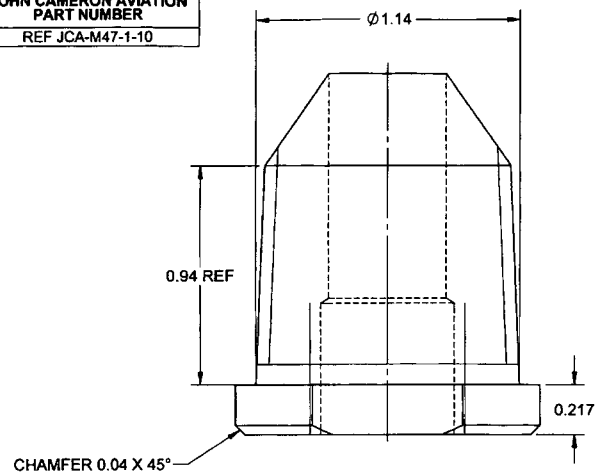
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.7
- 7) WEIGHT: 0.04 lbs

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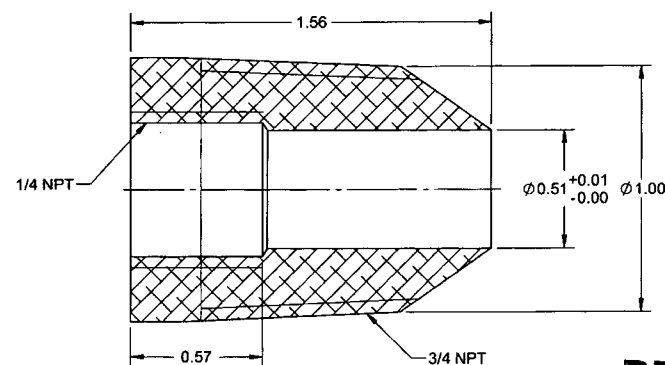
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	DD	D4000	SHEET 5 OF 8
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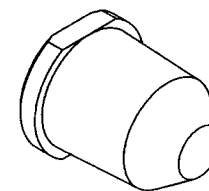
DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-7	REF JCA-M47-1-10



D4000-7 FUEL PICK UP FITTING



SECTION F-F



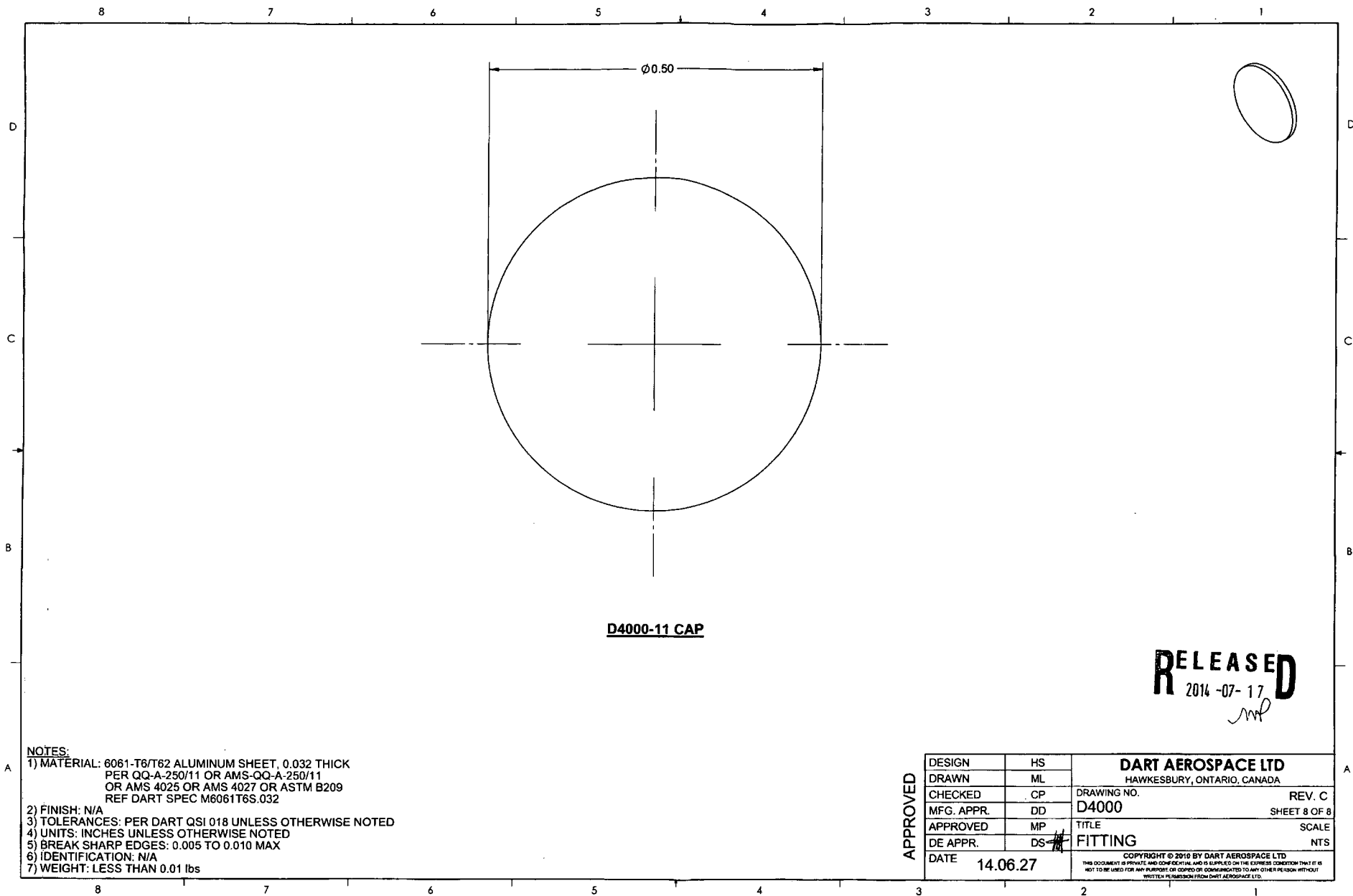
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

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DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	DD	D4000	SHEET 6 OF 8
APPROVED	MP	TITLE	SCALE
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2014-07-17
[Signature]



NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: LESS THAN 0.01 lbs

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DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	ML	
CHECKED	CP	DRAWING NO. D4000
MFG. APPR.	DD	REV. C SHEET 8 OF 8
APPROVED	MP	TITLE FITTING
DE APPR.	DS	SCALE NTS
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2014-07-17
mp

12/10/11
R. C. C.

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